

Split

Work Order ID 154116-2

Friday, December 02, 2016 10:59:08 AM

154116

Page 1

Item ID: D4928-042

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: 206A/B Leg Assembly RH

Stop *NS2*

Start Date: 1/9/2017 Start Qty: 4.00

4

Required Date: 1/17/2017 Req'd Qty: 4.00

4

Cust Item ID:

Reference:

Customer:

Approvals:

Process Plan:

VS

DAS
21
9-89

Date: 1/17/17

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4928

C

0.00

110

Small Fab

Small Fab

Memo

0.40

ALIGN PILOT HOLES IN D4928-1 WITH PILOT HOLES IN D4883-3 AND
D4884-3. DRILL OUT EACH HOLES USING A PILOTED DRILL AS PER
DWG.
REAM EACH HOLES USING REAMER, USING DART TOOL SETUP
DT9970 AS PER DWG.

2 0 17-1-23

DAS
19
9-89

120

120

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.01

2

DAS
38
9-89

JAN 23 2017

Work Order ID 154116

Friday, December 02, 2016 10:59:08 AM

154116

Page 2

Item ID: D4928-042

Revision ID:

Accept

N900040100

Setup Start ***NS1***

Item Name: 206A/B Leg Assembly RH

Stop ***NS2***

Start Date: 1/9/2017 Start Qty: 4.00

4

Required Date: 1/17/2017 Req'd Qty: 4.00

4

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Small Fab

Small Fab

0.00

0.32

Memo

INSTALL PIN/COLLAR AND END FITTING WITH HYSOL WHILE STILL
WET AS PER DWG USE DT9970
A/R HYSOL BATCH: 136671

2 0 17-1-25

DAS
19
9-00

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.01

2 0 0

DAS
38
9-00

JAN 25 2017

150

150

Outsource9

Outsource process - Laser Marking

Outsource process - Laser Marking

0.00

Memo

0.00

ISSUE P/O: 35122
OUTSOURCE VENDOR: P&L PRINTING
ENGRAVE P# AS PER DWG

C OF C IS REQUIRED

2 0 0

DAS
13
9-00

JAN 30 2017

Work Order ID 154116

Friday, December 02, 2016 10:59:08 AM

154116

Page 3

Item ID: D4928-042

Revision ID:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Item Name: 206A/B Leg Assembly RH

Start Date: 1/9/2017 Start Qty: 4.00

Required Date: 1/17/2017 Req'd Qty: 4.00

4***4***

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

160

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

0.01

2x SP17-02-7.

170

170

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.01

2

DAS
38
9-89

FEB 07 2017

180

180

Packaging

Packaging

Identify as per dwg & Stock Location: 51230

0.00

Memo

0.01

2 DAS
6
9-89

FEB 08 2017

Work Order ID 154116

Friday, December 02, 2016 10:59:08 AM

154116

Page 4

Item ID: D4928-042

Revision ID:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Item Name: 206A/B Leg Assembly RH

Start Date: 1/9/2017 Start Qty: 4.00

Required Date: 1/17/2017 Req'd Qty: 4.00

4

Cust Item ID:

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21 - Final Inspection - Work Order Release

0.00

190
QC

Quality Control

Memo

0.07

17/2/9



FEB 09 2017

Picklist Print

Page 1

Friday, December 02, 2016 10:59:17 AM

Work Order ID: 154116

154116

Parent Item: D4928-042

D4928-042

Parent Item Name: 206A/B Leg Assembly RH

Start Date: 1/9/2017

Required Date: 1/17/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 14.06.23 NEW ISSUE DD VERF:JLM IPP
REV:B 14.07.07 AS PER DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
HL32PB5-12		Purchased	No				Each	0.0000		16		DEC 05 2016	DAS 6 9-89
HI 32PB5-12									**	136894			
Hi-Lok Pin													
D4928-1		Manufactured	No				Each	2.0000		4		DEC 05 2016	DAS 6 9-89
D4928-1									**				
Strut													
					Location			Loc Qty	Loc Code				
					st138			2					
					150418			2					
D4883-3		Manufactured	No				Each	1.0000		4		DEC 05 2016	DAS 6 9-89
D4883-3									**	154164 X3			
End Fitting													
					Location			Loc Qty	Loc Code				
					ST134			1					
					152525			1					
D4884-3		Manufactured	No				Each	12.0000		4		DEC 05 2016	DAS 6 9-89
D4884-3									**				
End Fitting, Eye													
					Location			Loc Qty	Loc Code				
					ST134			12					
					121463			12					

Picklist Print

Page 2

Friday, December 02, 2016 10:59:18 AM

Work Order ID: 154116

Parent Item: D4928-042

Parent Item Name: 206A/B Leg Assembly RH

154116

D4928-042

Start Date: 1/9/2017

Required Date: 1/17/2017

Start Qty: 4.00

Required Qty: 4.00

HL86-5

Purchased

No

Each

392.0000

16

HI 86-5

Hi-Lok Collar

DAS
6
9-89

Location

Loc Qty

Loc Code

ST562

392

M129022

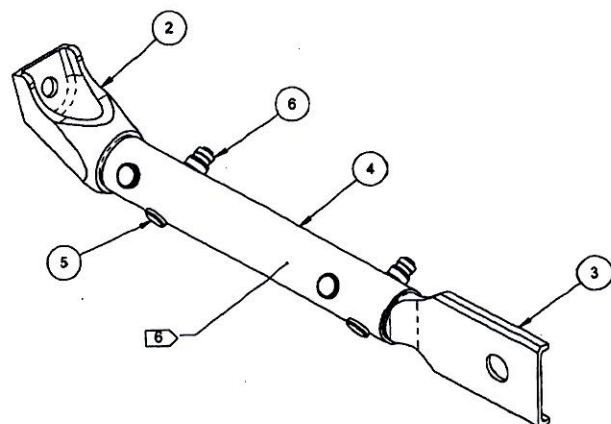
200

M129864

192

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 154116

VR
16/12/02



D4928-042 LEG ASSEMBLY, RH
(EQUIVALENT TO BELL P/N 208-082-102-001)

NOTES:

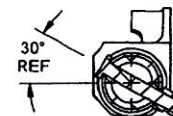
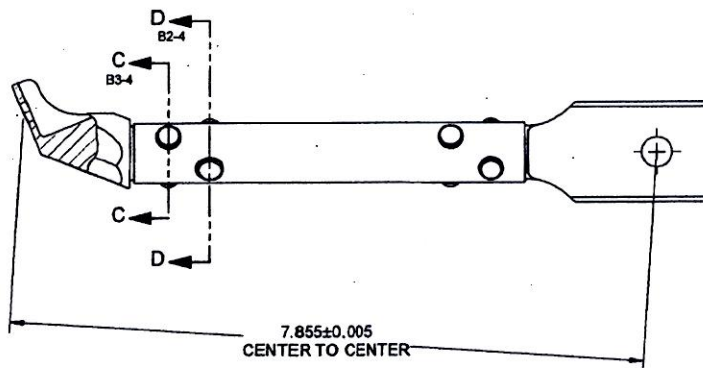
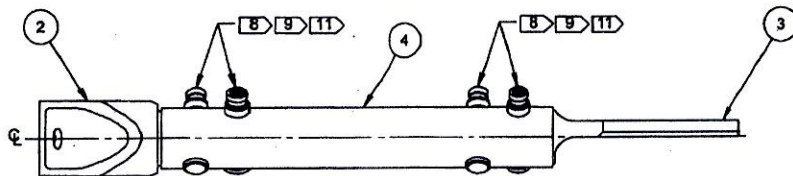
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.8
- 7) WEIGHT: 0.58 lbs
- 8) ALIGN PILOT HOLES IN D4928-1 WITH PILOT HOLES IN D4883-3 & D4884-3.
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.
REAM EACH HOLE USING P/N 31-219 (Ø 0.1810) REAMER, USING DART TOOL SETUP DT9970
- 9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA OR MAGNOBOND 6398 ADHESIVE WHILE STILL WET
- 10) ASSEMBLE PER DART TOOL DT9970
- 11) INSTALL HL32PB5-12 HI-LOK IN ORIENTATION SHOWN

ITEM	QTY -042	P/N	DESCRIPTION
1	X	D4928-042	LEG ASSEMBLY, RH
2	1	D4883-3	END FITTING
3	1	D4884-3	END FITTING, EYE
4	1	D4928-1	STRUT
5	4	HL32PB5-12	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR

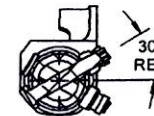
RELEASED
2014-07-07

APPROVED	DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	VS		
	CHECKED	HS	DRAWING NO. D4928	REV. C
	MFG. APPR.	JFS		SHEET 3 OF 5
	APPROVED	HS	TITLE LEG ASSEMBLY	SCALE NTS
	DE APPR.	DS	DATE 14.06.24	

COPYRIGHT © 2015 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD



SECTION C-C C7-4
2 PL



SECTION D-D C7-4
2 PL

D4928-042 LEG ASSEMBLY, RH
AUXILIARY VIEW

RELEASED
2014-07-07
mo

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	HS	DRAWING NO.	REV. C
MFG. APPR.	JFS	D4928	SHEET 4 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LEG ASSEMBLY	NTS
DATE	14.06.24	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO35122**

Purchase Order Date 1/30/2017

PO Print Date 1/30/2017

Page Number 1 of 2

Order From : VC-PL001
P & L PRINTING
19226 AIRPORT ROAD
SUMMERSTOWN, ONTARIO K0C 2E0
CANADA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

JAN 30 2017

Contact Name
Vendor Phone 613-931-1241

Ship To Contact
Ship To Phone
Ship Via: FedEx Overnight collect
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
----------	--	------------------------	--------------------------------------	----	--------------------------------	---------------	----------------

1	71400-45	DART AEROSPACE STAMP COLOR BLACK	2/6/2017 Yes 2/6/2017		1.00 Each	\$39.95	\$39.95
---	----------	-------------------------------------	-----------------------------	--	--------------	---------	---------

CL17102101

Line Total: \$39.95

Deliver To: SYLVIE L

2	154116	D4928-042 LEG ASSEMBLY	2/6/2017 Yes 2/6/2017		2.00	\$4.00	\$8.00
---	--------	---------------------------	-----------------------------	--	------	--------	--------

OAS
38
9-88

ENGRAVE PART # D4928-042

SP 17-02-7

Line Total: \$8.00

Note:

1/30/2017



19226 Airport Road
Summerstown, ON
K0C 2E0 Canada

Tel. 613-931-1241
Fax 613-931-2560
plprinting@bellnet.ca

PACKING SLIP

SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

DATE FEB 3, 2017

P.O NUMBER PO35122

ITEM DESCRIPTION

D4928-042 LEG ASSEMBLY ✓

QUANTITY

2 ✓

COMMENTS

ALL ITEMS HAVE BEEN LASER MARKED ✓

OAS
38
3-89

SP17-02-7.



19226 Airport Road
Summerstown, ON
K0C 2E0

plprinting@bellnet.ca

Tel.: 613 931-1241
Fax: 613 931-2560

www.plprinting.ca

Invoice

Number: 8936

Date: February 03, 2017

Bill To:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

Ship To:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

PO Number	Terms	Ship Via
35122		

Description	Quantity	Price	HST	Amount
Laser Metal Marking, D4928-042	2.00	4.00	✓	8.00
Sub-Total				\$8.00
13.00% on 8.00				1.04
Total				\$9.04

We do more than just print on paper!

*Whatever we make, we make it the best we possibly can.
We make it as good as if we were going to keep it for ourselves.*

H.S.T. No. 13301 4258

2% INTEREST CHARGED ON OVERDUE ACCOUNTS
PAY BY INVOICE NO STATEMENT WILL BE ISSUED

Thank You